

23/05

Dart Aerospace Ltd.

Date: Friday, 16/05/2008 7:45:50 AM
 User: Linda Lacelle

Process Sheet

08/05/21

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 39312
 Estimate Number : 10437
 P.O. Number :
 This Issue : 16/05/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL / MED FAB
 Previous Run : 38646

Drawing Name : WEARPLATE

Part Number : D33191
 Drawing Number : D3319 REV. B
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 23/05/2008

Qty: 42 Um: Eac

Written By :
 Checked & Approved By :
 Comment : Est: B 05.10.14 Added step 9, dwg rev B KJ/EC
 Est Rev:C Now on Waterjet 06-10-26 JLM

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S18GA	1010/1025/A21/6aA SHEET .048



16



Comment: Qty.: 0.6594 sf(s)/Unit Total: 7.9128 sf(s)
 1010/1025/A21/6aA SHEET .048
 Batch: 106603 B 8-5-20

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3319
 Dwg Rev: B B 8-5-20
 Prog Rev: B

2-Deburr if necessary B 8-5-20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr if necessary

vha

Done at step 4

2.2 08/05/21

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 39312

Part Number: D33191

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1- Form using DT8326 & DT8261 as per Dwg D3319 Rev: D

2- Form flat on press using DT8776 block

SB 07/05/21 (3)

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5 08/05/21 (x3)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Layout weld location as per Dwg D3319 using jig D3319-1T3

2- Weld hard surface using D3319-1T2 per QSI 004 and Dwg D3319 Rev: ____

Qty Part Number Description Batch

A/R N/A 7560 Hardcoat Rod H106762.

08-05-20 SP

(3x)

9.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

5 08/05/21 (x3)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/05/21 (x3)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:45 pm
320 °F
2:15 pm

M-L 08/05/21

(3x)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FB 08/05/21 (3)

Friday, 16/05/2008 7:45:50 AM
Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 39312

Part Number: D33191

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



3x

Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3319-1, B/N: BXXXXX

For Product Eligibility see PDA05-18

and Stock

Location: ST 496

8/5/21

SC

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/21

Comment: FINAL INSPECTION/W/O RELEASE

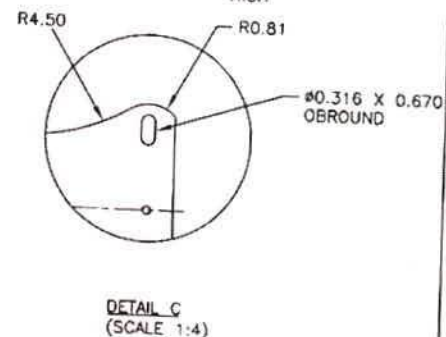
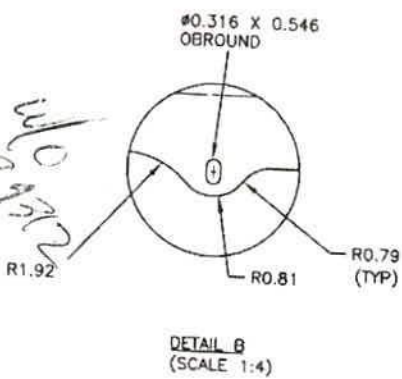
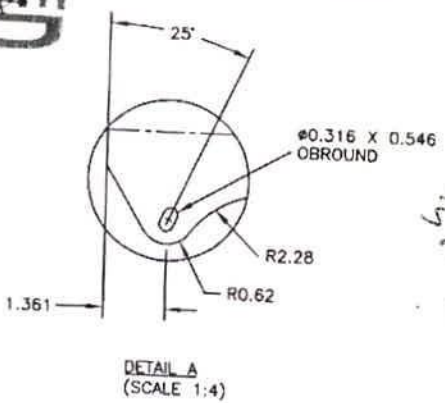
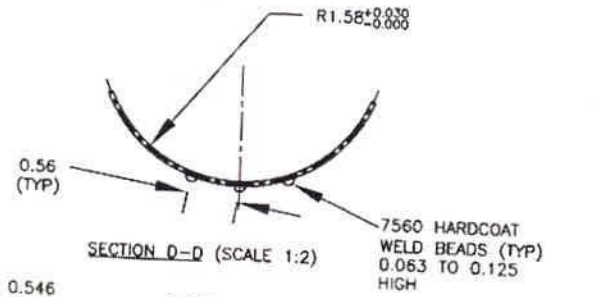
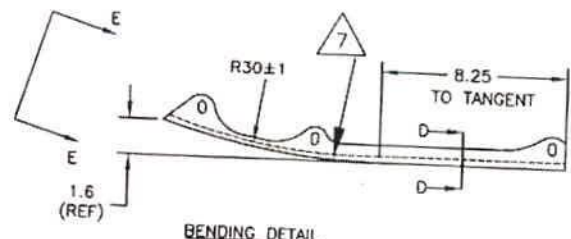
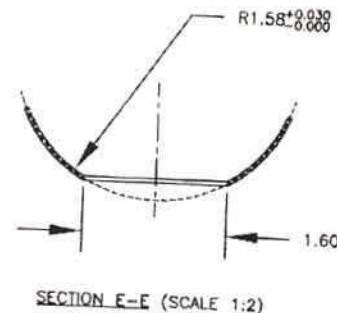
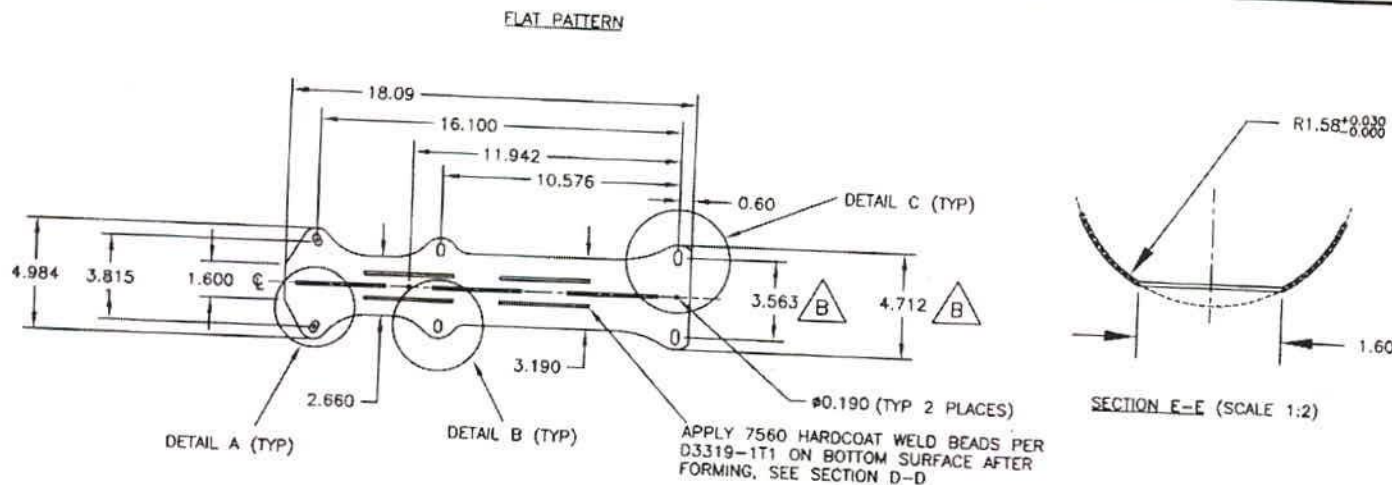
Job Completion



UMF 08-05-21

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
PH1	PH1	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
DATE	05.06.06	D3319
05.06.06	04.09.24	WEARPLATE
A	05.06.06	NEW ISSUE
B		WIDEN HOLES, REDUCE WIDTH -3/-5/-7
		SCALE
		1:8



- D3319-1 WEARPLATE
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
 - 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) PART IS SYMMETRICAL ABOUT CENTERLINE
 - 5) ALL DIMENSIONS IN INCHES
 - 6) WELD PER DART QSI 004
 - 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

RELEASED
05 07 30

